

Date: Friday, 22/05/2009 9:58:31 AM
 User: Julie Dawson

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : PANEL, POST LH, LOWER |
| Job Number : 48132 | |
| Estimate Number : 13945 | |
| P.O. Number : | Part Number : D39473 |
| This Issue : 22/05/2009 S.O. No. : | Drawing Number : D3947-3 |
| Prsht Rev. : NC | Project Number : IN0001 |
| First Issue : // Type : R&D THERMOFORMING | Drawing Revision : A PROTOTYPE 09.05.21 |
| Previous Run : | Material : MLEXS093F600607 |
| Written By : | Due Date : 22/05/2009 Qty: 1 Um: Each |
| Checked & Approved By : <u>JW 09.05.22</u> | |
| Comment : Est. Rev. A New Issue 09/05/22 DL | |

Additional Product

PROTOTYPE

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------------|-------------------------|
| 1.0 | MLEXS093F600607 | GE PLASTICS LEXAN SHEET |
|-----|-----------------|-------------------------|



Comment: Qty.: 3.7275 sf(s)/Unit Total : 3.7275 sf(s)
 GE PLASTICS LEXAN SHEET

M107574

09.05.22

| | | |
|-----|----------------|------------------------------|
| 2.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|

**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB

09/05/22

| | | |
|-----|----------------|------------------------------|
| 3.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
|-----|----------------|------------------------------|

**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB

09/05/22

X1

| | | |
|-----|---------------|-----------------------|
| 4.0 | THERMOFORMING | THERMOFORMING MACHINE |
|-----|---------------|-----------------------|

**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3947-3 and folio (FTA 3947-1 Prototype) using tool DT 9484

Dwg. Rev. AFolio Rev. A

BB

09/05/22

X1

| | | |
|-----|-----|--|
| 5.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

ENGINEERING
APPROVAL

BB

09/05/22

X1

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL, POST LH, LOWER

Job Number: 48132

Part Number: D39473

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



(X1)

Comment: SECOND CHECK

Wh. 09.05.22

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



(X1)

Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

Wh. 09.05.22

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(X1)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ENGINEERING
APPROVAL

Check dimensions to ensure conformity to drawing tolerances.

Wh. 09.05.22

9.0

QC5

INSPECT WORK TO CURRENT STEP



09.05.22

Comment: INSPECT WORK TO CURRENT STEP

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FOR ENGINEERING USE ONLY

09.05.22

N/A ENG USE ONLY

11.0

QC21

FINAL INSPECTION/W/O RELEASE



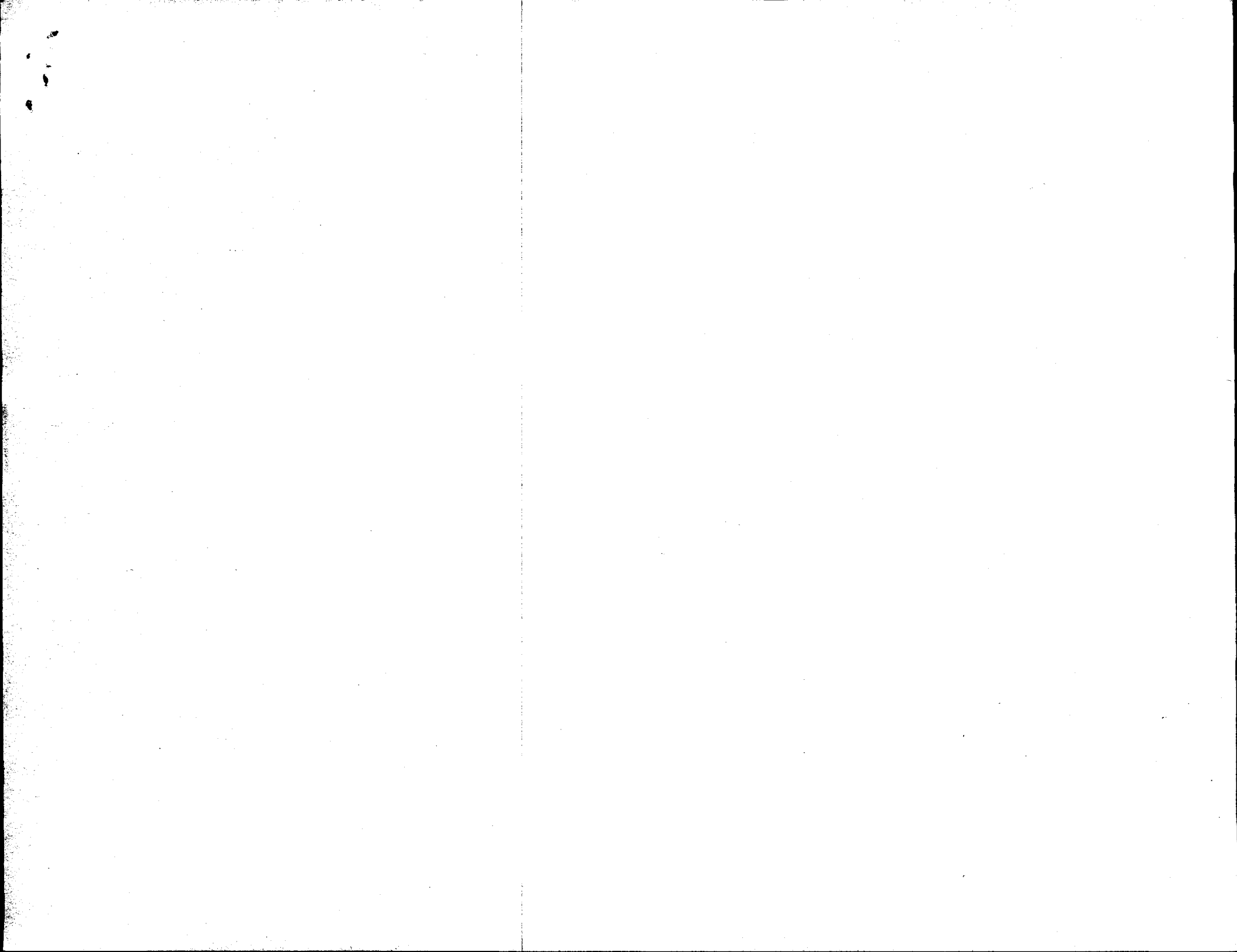
Comment: FINAL INSPECTION/W/O RELEASE

09.05.22 prototype

Job Completion



002803
MF
09-06-05



| | |
|--------------------------------|----------------------|
| DART AEROSPACE LTD | Work Order: 48132 |
| Description: | Part Number: D3947-3 |
| Inspection Dwg: D3947-3 Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

| Description | Accept | Reject | Method of Inspection | Comments |
|---|--------|--------|----------------------|----------|
| Inside Radii less than _____" N/A. | | | | |
| Shape Definition | ✓ | | | |
| Texture Retention | ✓ | | | |
| Material imperfections such as bumps, cracks, voids, scratching | ✓ | | | |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

Measured by: BB

Date: 09/05/22

TRIMMING SECTION

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| 1.8 | | 1.8 | ✓ | | | |
| .9 | | .9 | ✓ | | | |
| .5 | | .5 | ✓ | | | |
| .5 | | .5 | ✓ | | | |
| 0.050 | | 0.061 | ✓ | | | |
| 0.065 | | 0.080 | ✓ | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

Measured by: Wh.

Date: 09.05.22

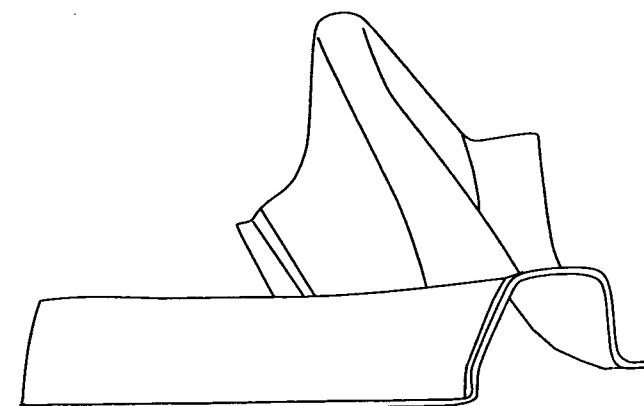
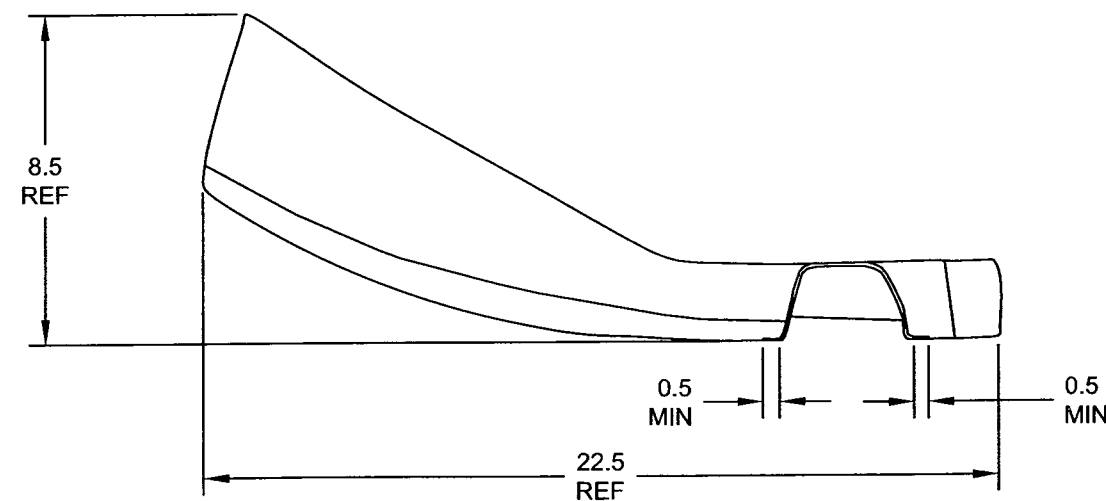
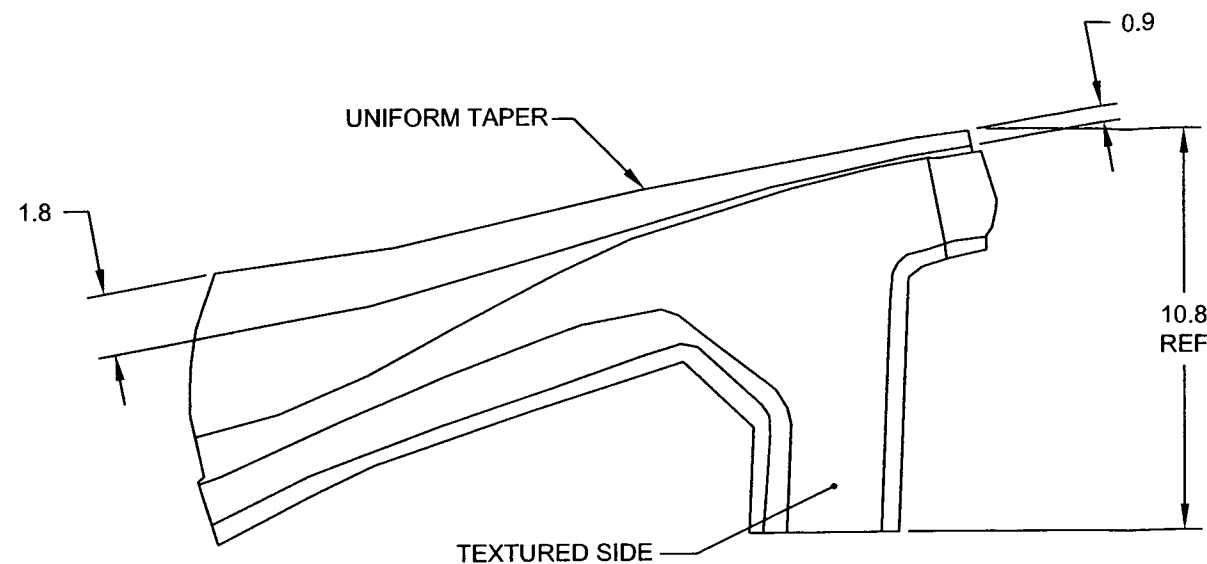
Audited by: BB

Date: 09/05/22

Prototype Approval: CP

Date: 09/05/22

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/DL | |



D3947-3 PANEL, LH

PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
CP 09.05.21

NOTES:

- 1) MATERIAL: F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK
REF DART SPEC MLEXS.093-F6006-07
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3947-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.55 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9484 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.065" ELSEWHERE

| | | | |
|--|-----------|--|--------------|
| DESIGN | <i>CP</i> | DART AEROSPACE LTD | |
| DRAWN | <i>PH</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>CP</i> | DRAWING NO. | REV. A |
| MFG. APPR. | | D3947 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | PANEL (AS 350/355) | NTS |
| DATE | 09.05.20 | COPYRIGHT © 2009 BY DART AEROSPACE LTD | |
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